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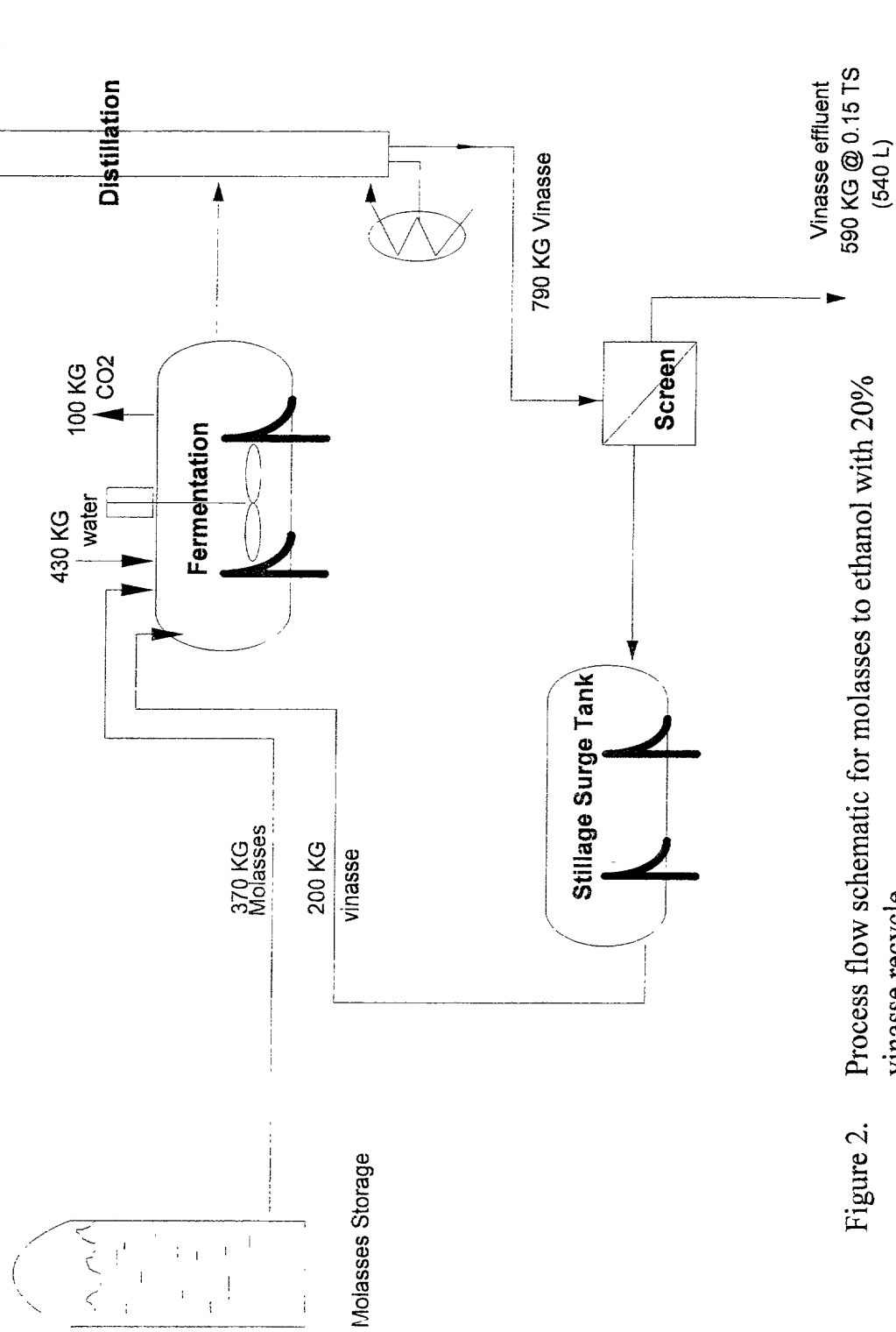


Figure 2. Process flow schematic for molasses to ethanol with 20% vinasse recycle

Figure 3. Osmolality of beet molasses as a function of molasses solids- model versus data.

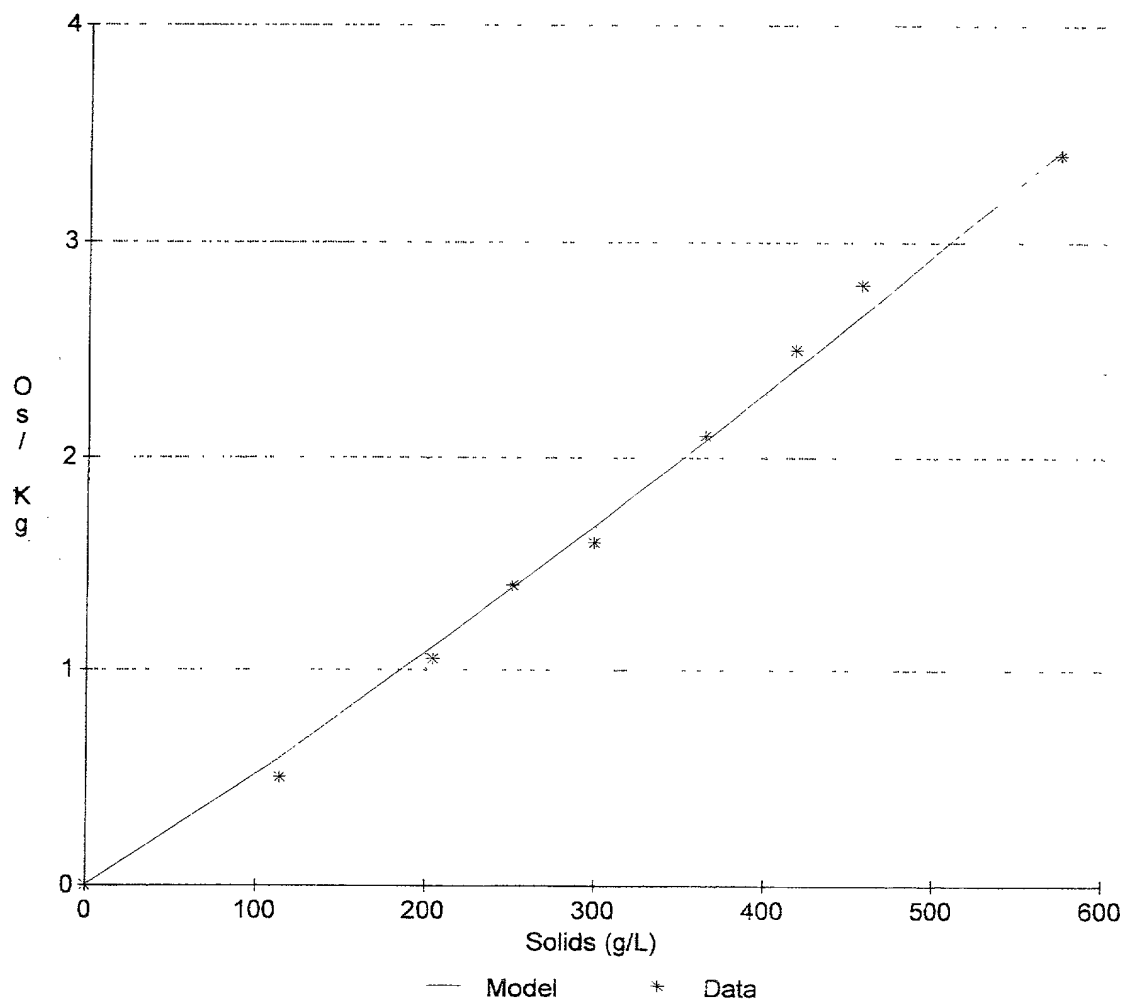


Figure 4. Consecutive Batch Mode (CBM) fermentation of beet molasses- data from 3 consecutive fermentations.

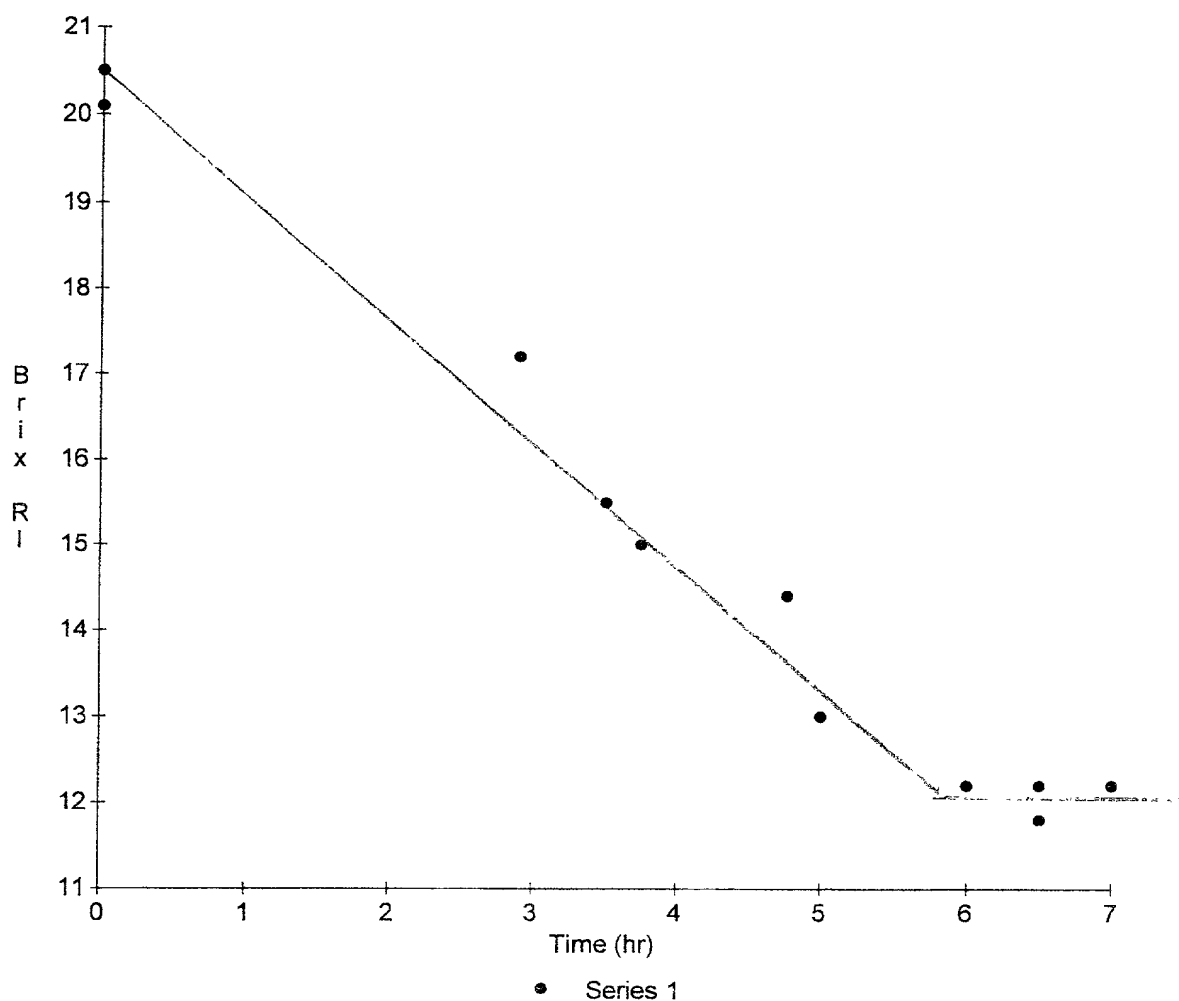
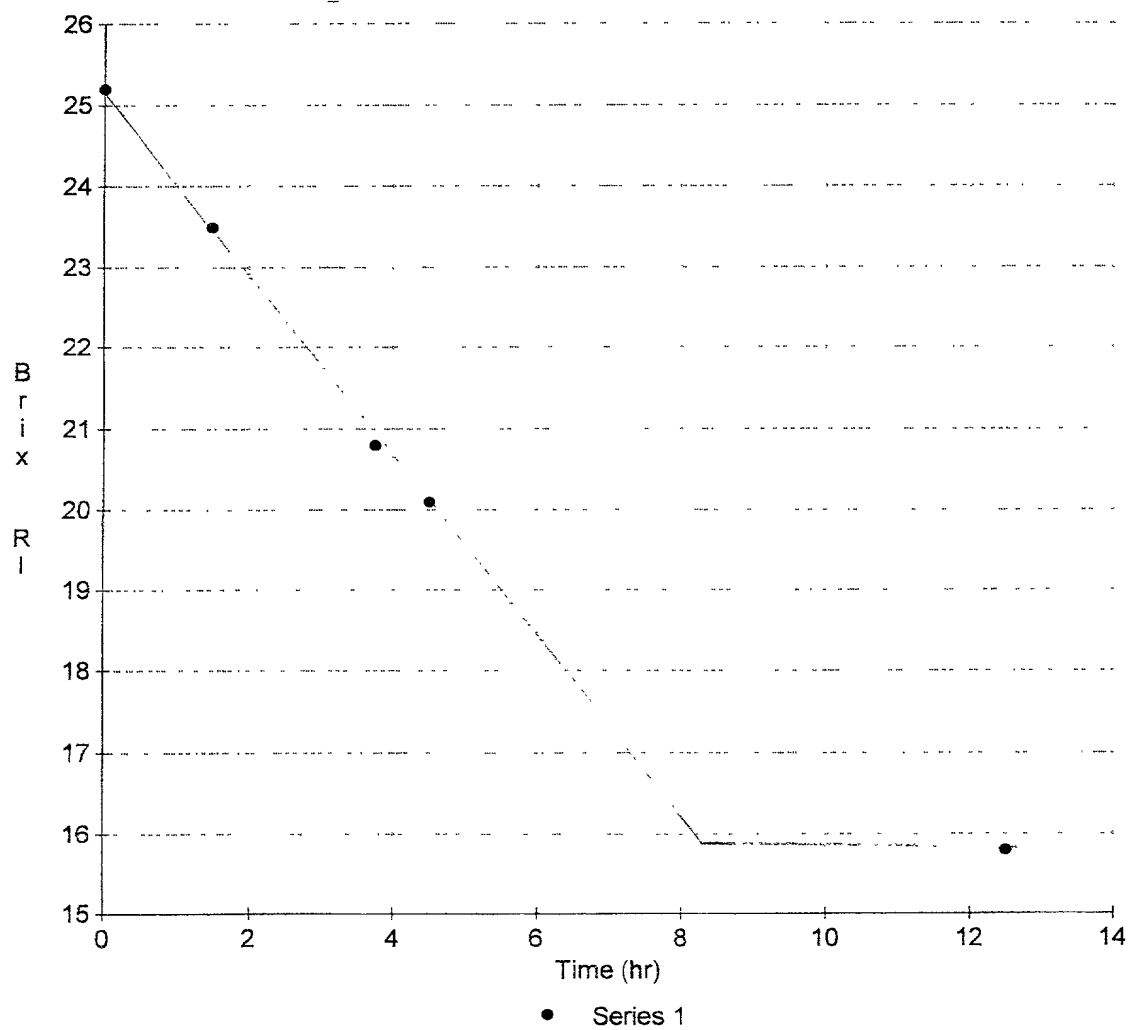


Figure 5. Consecutive Batch Mode (CBM) fermentation of beet molasses with 30% vinasse recycle.



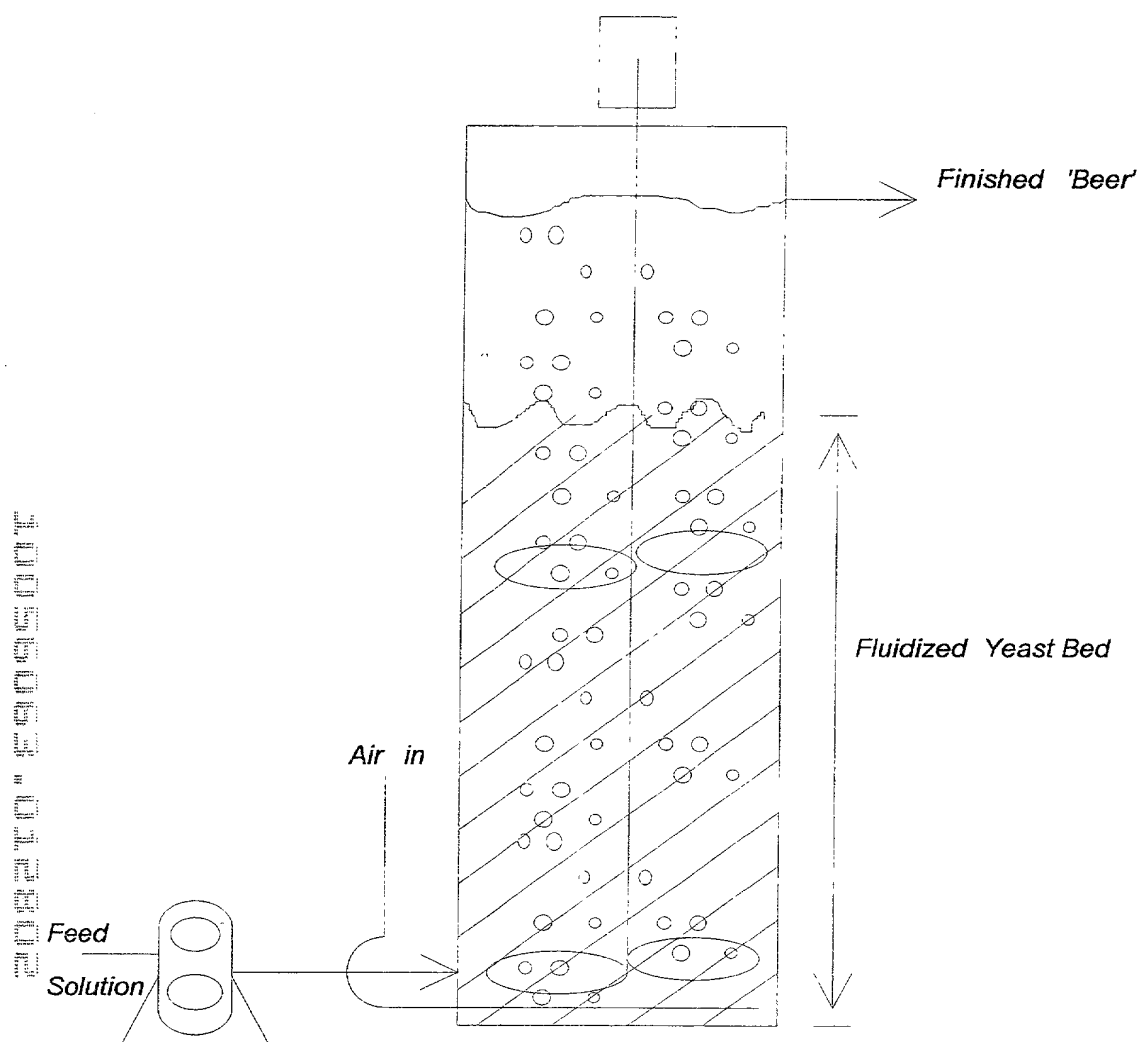


Figure 6. Schematic of Tower Reactor with a fluidized yeast bed.